

# Work Order ID 59379

June 3, 2010 7:09:45 AM



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Item ID: D044-717-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Cold Weather Baffle

Start Date: 6/03/10 Start Qty: 5.00



Cust Item ID:

Required Date: 6/07/10 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DC

Document Control

*BSV*

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D044-717-011CHG001

*8/10/06/02*

*10/06/03*

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

*6/14/07*

120

0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

*8/10/06/03*

*XS*

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Item ID: D044-717-011

Accept



Setup Start



Revision ID:

Item Name: Cold Weather Baffle

Stop



Start Date: 6/03/10 Start Qty: 5.00



Cust Item ID:

Required Date: 6/07/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D044-717-011 Location: _____ PPP Rev: <u>B</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*Per 6/9*

*10/06/10*

*MF*  
*10-6-9*

# Picklist Print

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Work Order ID: 59379

Parent Item: D044-717-011

Parent Item Name: Cold Weather Baffle

Comments: IPP Rev:B Removed Manufacturing 05-12-06 JLM

Start Date: 6/03/10

Required Date: 6/07/10

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3276-041		Manufactured	No			110	Each	5.0000	1	5			
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Baffle Assembly LH

Location

Loc Qty

Loc Code

176

5

58738

5

58738

D3276-042		Manufactured	No			110	Each	7.0000	1	5			
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Baffle Assembly RH

Location

Loc Qty

Loc Code

st175

7

54450

2

58723

5

54450 2x

58723 3x

B 5938/2x

D3383-1		Manufactured	No			110	Each	0.0000	1	5			
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Placard

AN526C1032R7



Screw

Purchased No

110 Each 114.0000

8

40

Location

Loc Qty

Loc Code

ST328

114

113064

63

113749

1

114056

50

113064

52723 3x

LC 10144/8

LC 146/7

(5)

# Picklist Print

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Work Order ID: 59379

Parent Item: D044-717-011

Parent Item Name: Cold Weather Baffle

Comments: IPP Rev:B Removed Manufacturing 05-12-06 JLM

Start Date: 6/03/10

Required Date: 6/07/10

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20426AD3-4

Purchased

No

110

Each

6,712.000

16

80

7



RIVET

## Location

## Loc Qty

## Loc Code

ST316

6712

104374

2712

110398

4000

1114379

MS21059L3

Purchased

No

110

Each

154.0000

8

40

7



Nut Plate

## Location

## Loc Qty

## Loc Code

ST301

100

114718

100

ST302

54

113749

10

114456

44

1114718

1114456 3570

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Shop Packet Print

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## 2.0 GENERAL NOTES

### COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

### CONTINUING AIRWORTHINESS

These installations should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D044-717. Refer to the Aircraft Maintenance Manual for standard shop practices not referred to in these Installation Instructions.

## 3.0 INSTALLATION PROCEDURE

The Dart D044-717-011 Cold Weather Baffle Kit should be installed as follows:

- 3.1 Temporarily locate the D3276-041 Baffle Assembly on the LH inlet as shown in Figure 1. Transfer drill the 4 holes to the aircraft and enlarge to  $\varnothing 0.203$ " (5.20mm). Ensure minimum edge distance of 0.300" from center of hole to edge of opening.
- 3.2 Drill  $\varnothing 0.098$ " holes for MS20426AD3-4 rivets that will be used to install the MS21059L3 nutplates. C'sink  $\varnothing 0.179$ " x 100° (4.55mm x 100°).
- 3.3 Deburr all drilled/c'sink holes and touch-up with primer per the Aircraft Maintenance Manual.
- 3.4 Install MS21059L3 nutplates on a/c holes using MS20426AD3-4 rivets. Install the D3276-041 Baffle Assembly using AN526C1032-7 screws. Torque screws 15-25 in-lb (2-3 Nm)
- 3.5 Repeat installation for RH side using D3276-042 Baffle Assembly.
- 3.6 Install D3383-1 Placard in full view of the pilot.

## 4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the installation.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-717-011	0.86 lb	0	0	160 in	138 in-lb
Cold Weather Baffle Kit	0.39 kg	0	0	4.06 m	1.6 m-kG

## 5.0 PARTS LIST

Qty -011	Part Number	Description
X	D044-717-011	COLD WEATHER BAFFLE KIT
1	D3276-041	BAFFLE ASSEMBLY, LH
1	D3276-042	BAFFLE ASSEMBLY, RH
1	D3383-1	PLACARD
8	AN526C1032-7	SCREW
16	MS20426AD3-4	RIVET
8	MS21059L3	NUTPLATE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries